












Date: Thursday, 7/19/2007 2:25:09 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE ASSEMBLY
Job Number : 33653	
Estimate Number : 12625	
P.O. Number : N/A	Part Number : D2127251903
This Issue : 7/19/2007 S.O. No. : N/A	Drawing Number : D212-725-1 REV A/B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A/B
Previous Run : 33133	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 7/19/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 10 Um: Each
Comment : Est Rev: A New Issue 07-01-04 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304TR0625W035 304 RD Tube .625 x .035W
	 
Comment: Qty.: 0.5775 f(s)/Unit Total : 5.7750 f(s) 304 RD Tube .625 x .035W Batch: <u>M103240</u> FF 07-07-26 10	
2.0	AN81810J nut
	 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s) nut Batch: <u>102850 x 8 / M 105206 x 12</u> FF 07-08-02 10	
3.0	MS2081910J sleeve
	 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s) sleeve Batch: <u>102850 x 8 / M 105206 x 12</u> FF 07-08-02 10	
4.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	 
Comment: SMALL & MEDIUM FAB RESOURCE 1	
1-Form tube as per Dwg D212-725-1& Template DT8906.	
2- Flare tube @ 37 deg ,Install sleeve & Nuts as per Dwg D212-725-1.	
QC5	INSPECT WORK TO CURRENT STEP
	 
ST WORK TO CURRENT STEP	
FF 07-08-02 10	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/03

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

te & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 33653

Part Number: D2127251903

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*7/18/12 SP*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*(10)*

Comment: FINAL INSPECTION/W/O RELEASE

*DDA/08/03*

Job Completion



*7-07-08-02*

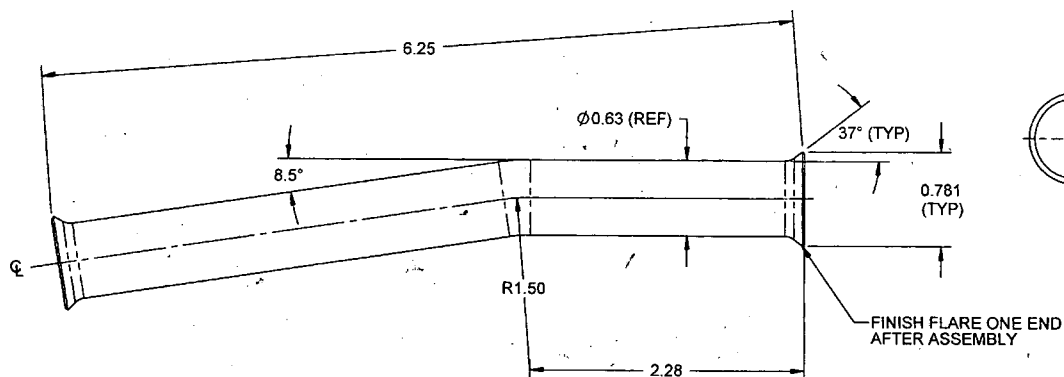
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

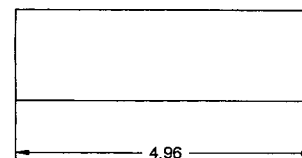
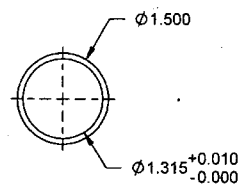
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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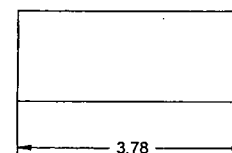
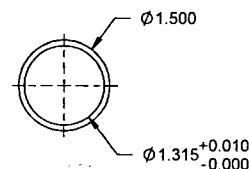
NOTE: Date & initial all entries



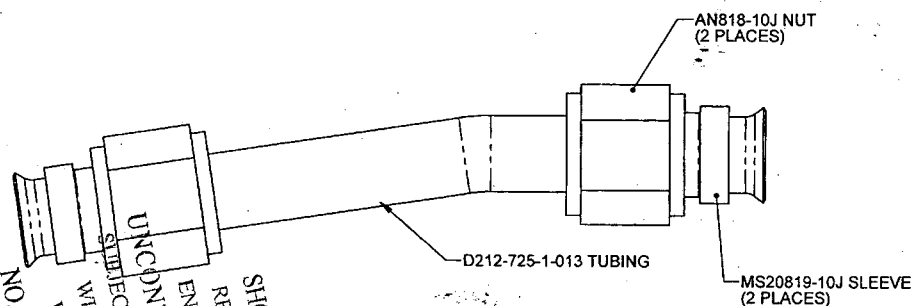
**D212-725-1-013 TUBING**  
MANUFACTURE PER TEMPLATE DT8906



**D212-725-1-025 SPACER**  
SCALE 1:2



**D212-725-1-027 SPACER**  
SCALE 1:2



**D212-725-1-903 TUBE ASSEMBLY**

**D212-725-1-013 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBING 0.625 O.D. x 0.035 WALL (REF. DART SPEC. M304TR0.625W0.035)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

**D212-725-1-025/-027 NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM (REF. DART SPEC. M6061TX.XXXW.XXX OR M6061T6R)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN	DC	DRAWN BY RF
CHECKED	DS	APPROVED
DATE	07.05.11	TITLE
		212S DETAIL PARTS
		SCALE 1:1
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HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D212-725-1** REV. B  
SHEET 6 OF 44